

Section 1. Registration Information

Source Identification

Facility Name:	Johanna Foods, Inc.
Parent Company #1 Name:	
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	06-Apr-2021
Postmark Date:	06-Apr-2021
Next Due Date:	06-Apr-2026
Completeness Check Date:	06-Apr-2021
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0014 8164
Other EPA Systems Facility ID:	08822JHNNFJOHAN
Facility Registry System ID:	

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	2350577
Parent Company #1 DUNS:	
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	JOHANNA FARMS ROAD
Street 2:	
City:	FLEMINGTON
State:	NEW JERSEY
ZIP:	08822
ZIP4:	0272
County:	HUNTERDON

Facility Latitude and Longitude

Latitude (decimal):	40.493056
Longitude (decimal):	-074.869444
Lat/Long Method:	Interpolation - Digital map source (TIGER)
Lat/Long Description:	Plant Entrance (General)
Horizontal Accuracy Measure:	10
Horizontal Reference Datum Name:	North American Datum of 1983
Source Map Scale Number:	

Owner or Operator

Operator Name:	JOHANNA FOODS, INC.
Operator Phone:	(908) 788-2200

Mailing Address

Operator Street 1:	P.O. Box 272
Operator Street 2:	
Operator City:	FLEMINGTON
Operator State:	NEW JERSEY
Operator ZIP:	08822
Operator ZIP4:	0272
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Matthew J. Call
RMP Title of Person or Position:	Vice Pres., Aseptic, Smoothie, Site
RMP E-mail Address:	mcall@johannafoods.com

Emergency Contact

Emergency Contact Name:	TIMOTHY A. HALL
Emergency Contact Title:	Director, Site Engineering
Emergency Contact Phone:	(908) 788-2324
Emergency Contact 24-Hour Phone:	(908) 391-8921
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	timhall@johannafoods.com

Other Points of Contact

Facility or Parent Company E-mail Address:
Facility Public Contact Phone:
Facility or Parent Company WWW Homepage Address:

Local Emergency Planning Committee

LEPC:	Raritan Township OEM
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Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	581
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	

Air Operating Permit ID:

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) Date:	06-Jan-2021
Last Safety Inspection Performed By an External Agency:	State environmental agency

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:	PrimaTech
Preparer Phone:	(614) 841-9800
Preparer Street 1:	50 Northwoods Boulevard
Preparer Street 2:	
Preparer City:	Colombus
Preparer State:	OHIO
Preparer ZIP:	43235
Preparer ZIP4:	
Preparer Foreign State:	
Preparer Foreign Country:	
Preparer Foreign ZIP:	

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents:	See Section 6. Accident History below to determine if there were any accidents reported for this RMP.
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Process Chemicals

Process ID:	1000115550
Description:	Refrigeration System
Process Chemical ID:	1000144472
Program Level:	Program Level 3 process
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Quantity (lbs):	65000
CBI Claimed:	
Flammable/Toxic:	Toxic

Process NAICS

Process ID:	1000115550
Process NAICS ID:	1000116983
Program Level:	Program Level 3 process
NAICS Code:	31199
NAICS Description:	All Other Food Manufacturing

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000093463

Percent Weight:	99.9
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Urban

Passive Mitigation Considered

Dikes:	Yes
Enclosures:	Yes
Berms:	
Drains:	
Sumps:	
Other Type:	

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000099355

Percent Weight:	99.9
Physical State:	Gas liquified by pressure
Model Used:	EPA's RMP*Comp(TM)
Wind Speed (m/sec):	3.0
Atmospheric Stability Class:	D
Topography:	Urban

Passive Mitigation Considered

Dikes:	Yes
Enclosures:	Yes
Berms:	
Drains:	
Sumps:	
Other Type:	

Active Mitigation Considered

Sprinkler System:	
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	
Other Type:	

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

Accident History ID: 1000072057

Date of Accident:	06-Feb-2019
Time Accident Began (HHMM):	0655
NAICS Code of Process Involved:	31199
NAICS Description:	All Other Food Manufacturing
Release Duration:	000 Hours 10 Minutes

Release Event

Gas Release:	Yes
Liquid Spill/Evaporation:	
Fire:	
Explosion:	
Uncontrolled/Runaway Reaction:	

Release Source

Storage Vessel:	
Piping:	
Process Vessel:	
Transfer Hose:	
Valve:	
Pump:	
Joint:	Yes
Other Release Source:	

Weather Conditions at the Time of Event

Wind Speed:	
Units:	
Direction:	
Temperature:	
Atmospheric Stability Class:	
Precipitation Present:	
Unknown Weather Conditions:	Yes

On-Site Impacts

Employee or Contractor Deaths:	0
Public Responder Deaths:	0
Public Deaths:	0
Employee or Contractor Injuries:	2
Public Responder Injuries:	0
Public Injuries:	0
On-Site Property Damage (\$):	0

Known Off-Site Impacts

Deaths:	0
Hospitalization:	0
Other Medical Treatments:	0
Evacuated:	0

Sheltered-in-Place: 0

Off-Site Property Damage (\$): 0

Environmental Damage

Fish or Animal Kills:

Tree, Lawn, Shrub, or Crop Damage:

Water Contamination:

Soil Contamination:

Other Environmental Damage:

Initiating Event

Initiating Event:

Equipment Failure

Contributing Factors

Equipment Failure: Yes

Human Error:

Improper Procedures:

Overpressurization:

Upset Condition:

By-Pass Condition:

Maintenance Activity/Inactivity:

Process Design Failure:

Unsuitable Equipment:

Unusual Weather Condition:

Management Error:

Other Contributing Factor:

Off-Site Responders Notified

Off-Site Responders Notified:

No, not notified

Changes Introduced as a Result of the Accident

Improved or Upgraded Equipment:

Revised Maintenance:

Revised Training:

Revised Operating Procedures:

New Process Controls:

New Mitigation Systems:

Revised Emergency Response Plan:

Changed Process:

Reduced Inventory:

None:

Other Changes Introduced:

Replaced o-ring

Confidential Business Information

CBI Claimed:

Chemicals in Accident History

Accident Chemical ID:	1000058234
Quantity Released (lbs):	2
Percent Weight:	100.0
Chemical Name:	Ammonia (anhydrous)
CAS Number:	7664-41-7
Flammable/Toxic:	Toxic

Section 7. Program Level 3

Description

Refrigeration System for cooling of Juice and Yogurt products during processing and for product storage.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000123918
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7

Process ID:	1000115550
Description:	Refrigeration System
Prevention Program Level 3 ID:	1000098858
NAICS Code:	31199

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	04-Feb-2021
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Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	09-Feb-2017
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The Technique Used

What If:	Yes
Checklist:	
What If/Checklist:	
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	
PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):	09-Feb-2017

Major Hazards Identified

Toxic Release:	Yes
Fire:	
Explosion:	
Runaway Reaction:	
Polymerization:	
Overpressurization:	
Corrosion:	
Overfilling:	
Contamination:	
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	

Earthquake:
Floods (Flood Plain):
Tornado:
Hurricanes:
Other Major Hazard Identified:

Process Controls in Use

Vents:	
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	
Dikes:	Yes
Fire Walls:	
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	Yes
Neutralization:	
None:	
Other Mitigation System in Use:	

Monitoring/Detection Systems in Use

Process Area Detectors:	Yes
Perimeter Monitors:	
None:	
Other Monitoring/Detection System in Use:	

Changes Since Last PHA Update

Reduction in Chemical Inventory:	
Increase in Chemical Inventory:	Yes
Change Process Parameters:	

Installation of Process Controls:	Yes
Installation of Process Detection Systems:	Yes
Installation of Perimeter Monitoring Systems:	
Installation of Mitigation Systems:	Yes
None Recommended:	
None:	
Other Changes Since Last PHA or PHA Update:	

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):	04-Feb-2021
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Training

Training Revision Date (The date of the most recent review or revision of training programs):	04-Feb-2021
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The Type of Training Provided

Classroom:	Yes
On the Job:	
Other Training:	

The Type of Competency Testing Used

Written Tests:	Yes
Oral Tests:	
Demonstration:	
Observation:	
Other Type of Competency Testing Used:	

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures):	04-Feb-2021
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Equipment Inspection Date (The date of the most recent equipment inspection or test):	30-Nov-2020
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Equipment Tested (Equipment most recently inspected or tested):	7 COMPRESSORS, 135 EVAPORATORS, 2 ACCUMULATORS, 2 TRANSFER TANKS, 1 RECEIVER, 1 STORAGE TANK, 5 CONDENSERS.
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Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):	25-Nov-2019
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Change Management Revision Date (The date of the most recent review or revision of management of change procedures):	04-Feb-2021
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Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review): 25-Nov-2019

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit): 04-Feb-2021

Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit): 04-Feb-2021

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)): 06-Feb-2019

Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation): 06-Feb-2019

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans): 04-Feb-2021

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures): 04-Feb-2021

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures): 04-Feb-2021

Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):

Confidential Business Information

CBI Claimed:

Section 8. Program Level 2

No records found.

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?): Yes

Facility Plan (Does facility have its own written emergency response plan?): Yes

Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?): Yes

Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?): Yes

Healthcare (Does facility's ER plan include information on emergency health care?): Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan): 04-Feb-2021

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees): 30-Dec-2020

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated): Raritan Township OEM

Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated): (908) 782-7662

Subject to

OSHA Regulations at 29 CFR 1910.38: Yes

OSHA Regulations at 29 CFR 1910.120:

Clean Water Regulations at 40 CFR 112: Yes

RCRA Regulations at CFR 264, 265, and 279.52:

OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:

State EPCRA Rules or Laws: Yes

Other (Specify):

Executive Summary

RMP EXECUTIVE SUMMARY

Accidental Release Prevention and Emergency Response

Johanna Foods, Inc. is committed to providing a safe environment for its employees as well as the surrounding community. Johanna Foods, Inc. has operated its ammonia refrigeration system following its RMP Program. The RMP Program was developed in 1991 to comply with New Jersey's Toxic Catastrophe Prevention Act. The Standard Operating Procedures, Preventative Maintenance Program, Management of Change Program, Emergency Response Plan, and other elements of the RMP Program have developed over the years to further improve the safety, reliability, and risk reduction of the ammonia refrigeration system.

Johanna Foods, Inc.

Johanna Foods, Inc. has three production plants on one site. The Juice Plant packages chilled juice products in half gallon, quart and pint paper and/or plastic containers that require refrigeration for processing and storage. The Aseptic Plant packages juice products in Brik Pak containers (drink boxes) in a variety of sizes and flavors that requires refrigeration for processing but not for storage. The Aseptic Plant also packages juice products in plastic containers that require refrigeration for processing and storage. The Yogurt Plant packages yogurt products in cup containers of various sizes, styles, and flavors that require refrigeration for processing and storage. Anhydrous ammonia is the regulated chemical that is used as the refrigerant. The quantity of anhydrous ammonia contained in the refrigeration system on site varies up to 65,000 pounds. The anhydrous ammonia is not consumed or produced by the refrigeration system. The refrigeration system circulates the anhydrous ammonia converting it from a liquid to a vapor to create cooling, then condensing the vapor back to a liquid to be used again.

General Accidental Release Prevention Program and Chemical-specific Prevention

Johanna Foods, Inc. has operated its ammonia refrigeration system following its RMP Program developed in 1991 to comply with New Jersey's Toxic Catastrophe Prevention Act. The Standard Operating Procedures are used for every task performed on the refrigeration system. All equipment is checked daily using checksheets from the S.O.P.'s Steady State Operations section. The Preventative Maintenance Program requires checksheets to inspect all refrigeration equipment in greater detail every six months, yearly testing of all safety interlocks and controls, and a five year schedule to replace safety relief valves. Any modification to the system is performed following the Management of Change Program. The M.O.C. requires a dispersion analysis to determine if the change could cause offsite impact or not. Offsite impact would result in performing a risk assessment of the change to identify all hazards and items to further reduce the risk of a release. All EHS operators are trained in all aspects of the RMP and annual refresher training is performed highlighting any changes to procedures or equipment.

Five Year Accident History

There have been no reportable accidents.

Emergency Response Plan

Johanna Foods, Inc. has an Emergency Response Plan that addresses emergency situations including an anhydrous ammonia release. This description will address procedures for an anhydrous ammonia release. There are procedures to follow for anyone who discovers a potential release to notify the Johanna Foods, Inc. guard shack. The guard would notify an EHS operator, by radio, to investigate the potential release. If the EHS operator finds a release he sounds the ammonia release evacuation alarm that sounds in the effected area. The site personnel evacuate the area, lead by an Evacuation Coordinator (EVC), who upon meeting at the designated evacuation area, conducts a headcount. The guard also follows procedures to notify the Emergency

Response Coordinator (ERC), or an alternate, to command the Emergency Response Team (ERT). The ERT members at the effected area don SCBAs and perform a search of the effected area. The ERC radios the EVC by radio for the result of the headcount and informs the response team of any missing personnel to search for. The ERC follows the Emergency Response Plan which includes procedures on how to contact local emergency responders such as police, fire department, rescue squad, and LEPC. Once all personnel are accounted for the EHS operators of the ERT start to isolate the release and monitor the area. The ERT is made up of EHS operators, production operators who have first aid training, and various maintenance personnel to assist in an emergency. Site personnel are trained annually on the evacuation procedures. The ERT is trained annually on the procedures of the Emergency Response Plan and the use of Emergency Response Equipment. One rollout drill is conducted per year.

Planned Changes to Improve Safety

Johanna Foods, Inc. follows the RMP to maintain the refrigeration system in a safe manner. Any additions to the system are performed using the Management of Change procedure to ensure that all new equipment is installed in the safest configuration. The five year Risk Assessments also analysis all equipment and procedures to ensure that all actions are taken to reduce the risk of any accidental releases.